

Date: Wednesday, 9/12/2007 12:12:56 PM
User: Kim Johnston

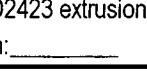
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 34587					
Estimate Number	: 10256					
P.O. Number	: N/A		Part Number	: D22303		
This Issue	: 9/12/2007	S.O. No.	: N/A	Drawing Number	: D2230 REV F	
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: F		
Previous Run	: 30993		Material	: N/A		
Written By	:		Due Date	: 10/5/2007		
Checked & Approved By	:		Qty: 200 Um: Each			
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
		
		
	Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)	
	Lug Extrusion	
	D2423	
	Batch: <u>33310</u>	
2.0	BAND SAW	BAND SAW
		
	<u>N/A cut at Mates</u>	
	Comment: Band Saw	
	Cut D2423 extrusion to 0.82"	
	Batch: _____	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
	<u>Issue by to Mates 4576</u>	<u>10/09/13</u>
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Machine per folio D2230-3	
	Check for crack while loading into the machine.	
		<u>Machine per drawing D2230 Rev F</u>
		<u>7/8/13</u>

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per filio D2280 3

~~Check for crack while loading into the machine~~

4.0	QC2	INSPECT
		QC#5
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 ~~108~~  *W* *1A* SECOND CHECK

Comment: ~~SECOND STRIKE~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 34587

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

coated

SA0 07-10-04 200

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



200X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SA0 M. 07/10/04

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA0 07/10/04

9.0 POWDER COATING

POWDER COATING



200X

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M. 07/10/04

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



200X

SA0 07-10-04

Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SA0 07/10/05 200

12.0 QC21

FINAL INSPECTION/W/O RELEASE



200

Comment: FINAL INSPECTION/W/O RELEASE

SA0 07/10/05

Job Completion



SA0 07/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

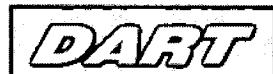
DART AEROSPACE LTD	Work Order:	34587
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

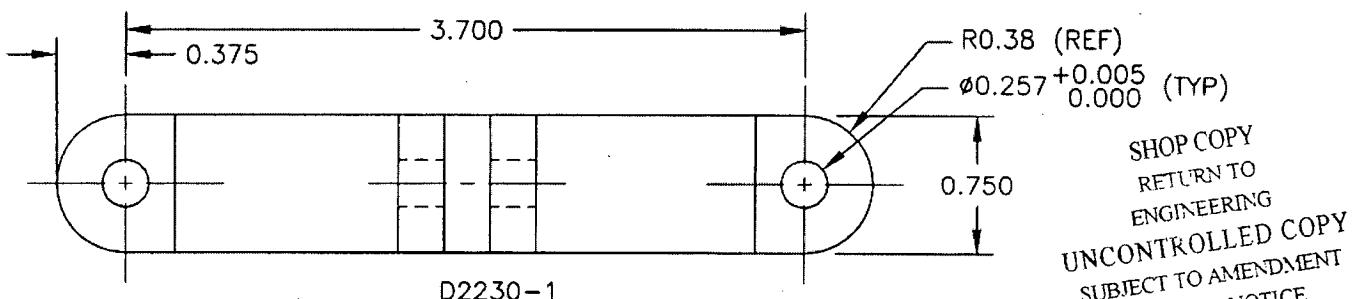
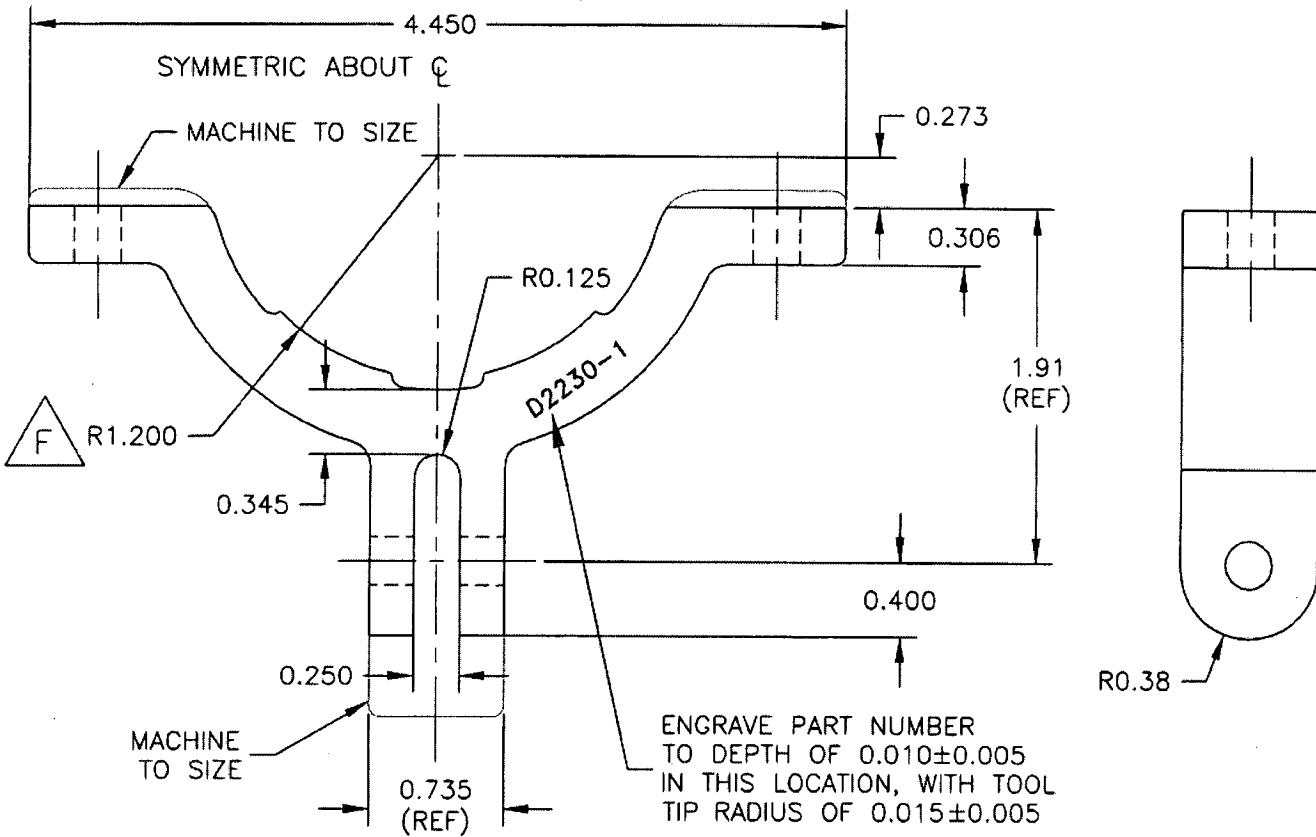
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	EE



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE		SCALE 1:1
99.12.13		MOUNTING LUG
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34587

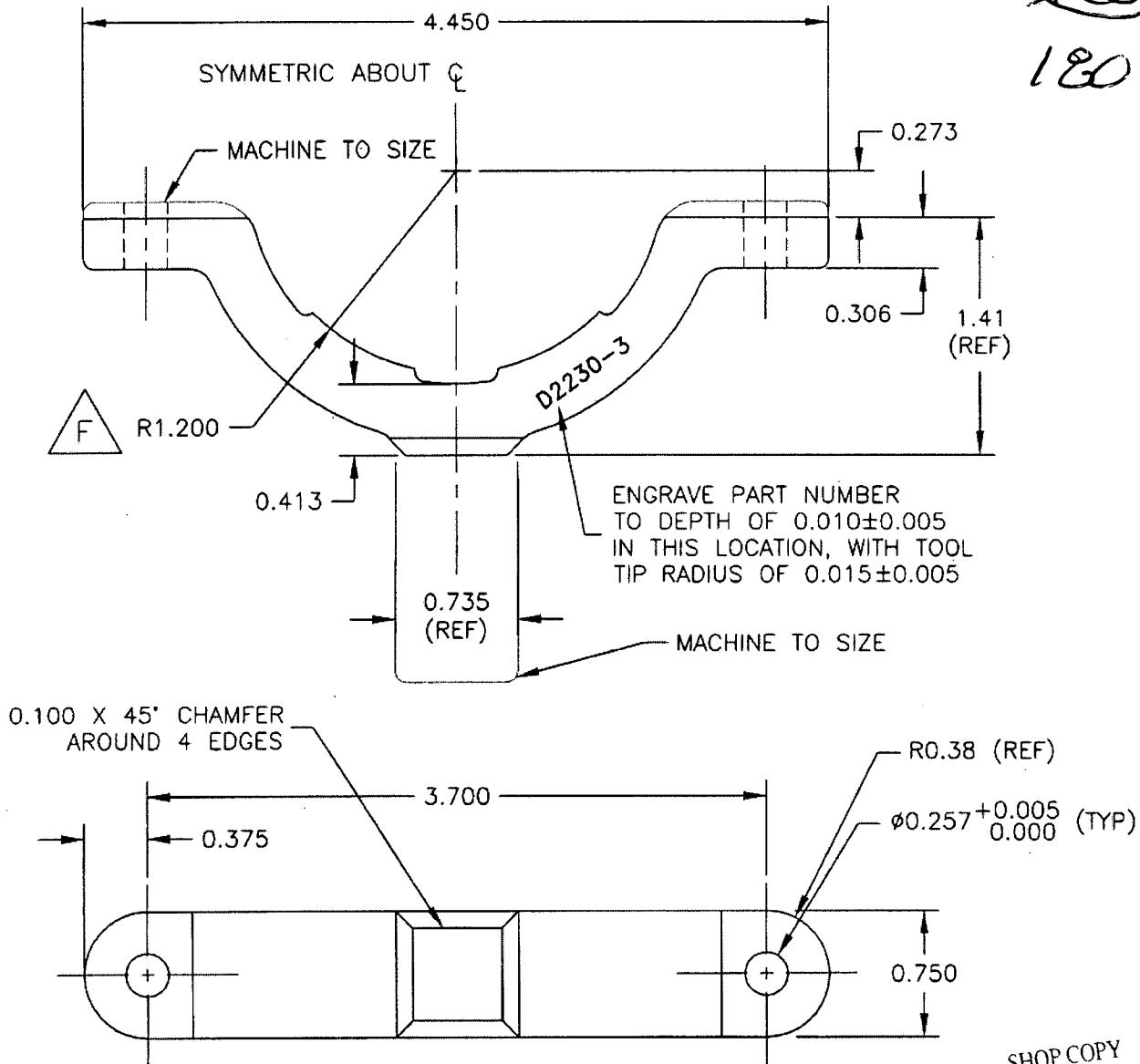


COPY ISSUED
44

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	APPROVED	<i>✓</i>	DRAWING NO. D2230 REV. F SHEET 2 OF 2
DATE	99.12.13			TITLE MOUNTING LUG SCALE 1:1

RELEASED
99.12.21 DS

170
180



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24587



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug B34587	4576

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Shig Nalz".

Vankleek Hill, September 27, 2007

